

Work Order ID 145216

May 04, 2016 1:59:55 PM

145216

Page 1

Item ID: D2933-1UP Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: 206 Saddle Left-Unpainted
Start Date: 5/9/2016 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 5/24/2016 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: SEA Date: 5/16/2016 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2933	Rev C								

100

0.00

100

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

Program part number and batch number.1-Inspect part number and batch number are programmed correctly.2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per

5

16-05-20

110

0.00

110

Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

0.00

Machine Keyway and inspect per attached dimension sheet

5

16-05-20

120

0.00

120

QC

Quality Control

QC1- Inspection performed by CMM

Memo

0.00

5

16-05-20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Page 3

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160	Identify as per dwg & Stock Location: <u>57405</u>	0.00							
160									
Packaging	Memo	0.00				<u>5</u>	<u>DAS</u> <u>6</u>		
Packaging							<u>9-89</u>		MAY 26 2016
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

MLJ MAY 27 2016
Lm 16/05/27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

May 04, 2016 2:00:03 PM

Page 1

Work Order ID: 145216

145216

Parent Item: D2933-1UP

D2933-1UP

Parent Item Name: 206 Saddle Left-Unpainted

Start Date: 5/9/2016

Required Date: 5/24/2016

Start Qty: 5.00

Required Qty: 5.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	59.0000	1	5			

D6101-001

Saddle Billet

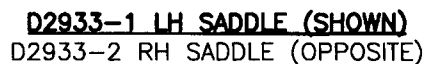
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT042	59	
132708	1	
137755	1	
141200	37	
143463	20	

5

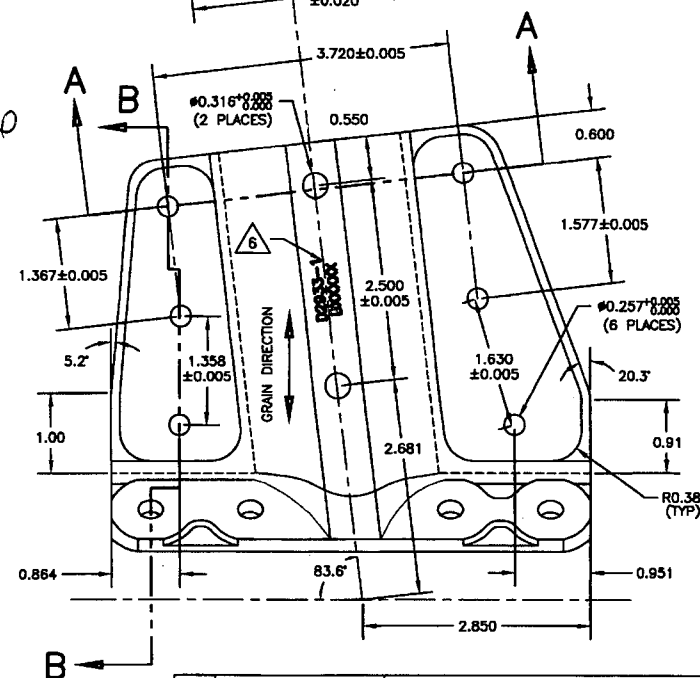
P16-05-19

D6101-001

B143463



- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	 DART AEROSPACE USA, INC. BELLEVILLE, MO
CHECKED	APPROVED	
DATE		DRAWING NO. D2933
06.11.09		TITLE SADDLE INSIDE
		REV. C SHEET 1 OF 2 SCALE 2:1

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OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

DART AEROSPACE LTD				Work Order:	145216
Description: 206 Saddle, Inboard, Left side				Part Number:	D2933-1
Inspection Dwg: D2933 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article**

 ☐ **Prototype**

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	0.100	0.140		.129	.125	.125	.125	.125
B	0.100	0.140		.130	.126	.126	.124	.124
C	0.100	0.140		.112	.115	.115	.117	.117
D	0.210	0.230		.221	.220	.221	.220	.220
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		.510	.510	.510	.510	.510
I	1.572	1.582		1.577	1.577	1.577	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		.258	.258	.258	.258	.258
L	0.312	0.317		.313	.313	.313	.313	.313
M	0.235	0.240		.235	.237	.235	.237	.237
N	0.100	0.140		.121	.120	.121	.121	.126
O	0.540	0.560	392	.552	.551	.549	.5475	.548
P	0.490	0.510	3435	.4985	.502	.4985	.501	.500
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720
R	2.470	2.510		2.492	2.492	2.492	2.493	2.492
S	0.240	0.270		.250	.250	.250	.249	.249
T	0.100	0.180		.130	.136	.137	.136	.138
U	1.625	1.635		1.630	1.630	1.630	1.630	1.630
V	1.362	1.372		1.367	1.367	1.367	1.367	1.367
W	0.316	0.321		.316	.316	.316	.316	.316
X	1.125	1.145		1.135	1.135	1.135	1.135	1.135
Y	1.565	1.585		1.575	1.575	1.575	1.575	1.575
Z	0.178	0.198		.188	.188	.188	.188	.188
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

Measured by: <i>[Signature]</i> 16-05-17	Date:
Audited by: <i>[Signature]</i>	Date: 16/05/24
Prototype Approval: 9-89 N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	<i>[Signature]</i>